

Work Order ID 62583

Monday, October 04, 2010 1:48:23 PM



Page 1

Item ID: PB67-43001-01

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Blade Fold Assembly

Start Date: 10/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *WKF*

Date: *10-10-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-01

Rev C

Pick kit 10/10/12/13 sl

0.00

100



Small Fab

0.00

Small Fab

Memo

1- Assemble as per dwg and notes on dwg B67-43001 and use 242 threadlock

Blue

A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK Blue batch: *M109687*

A/R touch up paint with sandflex green

batch: *M112961*

10.10.15

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

10/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/2010
MF
10-10-20

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THE UNIVERSITY OF CHICAGO

Required Qty: 1.00

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107  SPRING SLOTTED PIN		Purchased	No			100	Each	165.0000	8	8		10/10/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST400				165					
					112813			65			8		
					115827			100					
30345T22  8" LANYARD		Purchased	No			100	Each	21.0000	2	2		10/10/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST401				21			2		
					108973			2					
					112853			19					
30345T24  LANYARDS		Purchased	No			100	Each	46.0000	2	2		10/10/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST401				46			2		
					111351			2					
					112853			44					

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Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-10A Purchased No 100 Each 118.0000 2 2
Bolt



10/10/12 SP

Location	Loc Qty	Loc Code
ST356	118	
113422	1	
114523	77	
115835	40	

AN4-13A Purchased No 100 Each 480.0000 2 2
Bolt



10/10/12 SP

Location	Loc Qty	Loc Code
ST358	480	
115159	480	

AN4-15A Purchased No 100 Each 577.0000 4 4
Bolt



10/10/12 SP

Location	Loc Qty	Loc Code
ST338	112	
ST358	465	
107737	12	
108868	60	
109148	4	
111295	52	
112905	12	
114232	3	
114292	32	
114615	56	
114784	58	
115108	76	
115371	100	

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN6-11A Purchased No
BOLT



100 Each 84.0000



2
10/10/2010

Location	Loc Qty	Loc Code
ST342	84	
105558	4	
111177	30	
114437	50	

AN6-20A - 11A 10.10.15 Purchased No
Bolt



100 Each 58.0000



2
10/10/2010

Location	Loc Qty	Loc Code
ST342	58	
110915	28	
114941	30	

AN8-13A Purchased No
BOLT



100 Each 18.0000



2
10/10/2010

Location	Loc Qty	Loc Code
ST345	18	
110915	18	

BSP43 Purchased No
RIVET



100 Each 62.0000



4
10/10/2010

Location	Loc Qty	Loc Code
ST284	62	
110704	50	
111127	12	

W/O: 62583		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.10.15	}	ANG-20A BOLT TOO LONG. CHANGE TO ANG-16A BOLT.				10.10.15	
		PERMANENT CHANGE. CREATE CAR TO IMPLEMENT CHANGE ON DWG. LEVEL.		10.10.20			

Part No: PB6743001-01 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

CR3213-4-05

Purchased

No

100

Each

140.0000

2

2



cherry rivet



10/10/12 S

Location

Loc Qty

Loc Code

ST312

140

108473

41

108991

99

2

D3445-041

Manufactured

No

100

Each

5.0000

1



Belt Assembly



10/10/12 S

Location

Loc Qty

Loc Code

ST441

5

52615

5

D3447-3

Manufactured

No

100

Each

7.0000

2



Square Spacer



10/10/12 S

Location

Loc Qty

Loc Code

ST441

7

41351

1

58012

6

D3447-7

Manufactured

No

100

Each

8.0000

2



Clevis



10/10/12 S

Location

Loc Qty

Loc Code

ST441

8

52665

8

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3447-9

Manufactured No

100

Each

8.0000

2



Swing Arm



10/10/10 SP

Location

Loc Qty

Loc Code

ST442

8

46263

2

57745

6

D3451-041

Manufactured No

100

Each

2.0000

1



Handle and Lock-Down Assembly



10/10/10 SP

Location

Loc Qty

Loc Code

ST442

2

52565

2

D3451-047

Manufactured No

100

Each

2.0000

1



Handle and Lock-Down Assembly



10/10/10 SP

Location

Loc Qty

Loc Code

ST442

2

52568

2

D3922-1

Manufactured No

100

Each

16.0000

2



Clip



10/10/10 SP

Location

Loc Qty

Loc Code

ST096

16

48459

16

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS17984-C408 Purchased No
PIN, QUICK RELEASE



Location Loc Qty Loc Code

ST314 13
111279 3
~~112940~~ 10



2 2
~~10/10/10~~ 10.10.15

MS17984-C418 Purchased No
PIN, QUICK RELEASE

Location Loc Qty Loc Code

ST314 24
~~111359~~ 2
~~112940~~ 2
114523 20
ST463 6
114416 6



2 2
10/10/12

MS21042L3 Purchased No
Nut

Location Loc Qty Loc Code

ST300 2684
114523 49
~~114784~~ 1635
115835 1000



2 2
10/10/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62583

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Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010


Start Qty: 1.00

Required Qty: 1.00

MS21042L4 Purchased No 100 Each 4,434.000 8

 Nut


Location	Loc Qty	Loc Code
ST300	4434	
113422	68	
114523	8	
114718	16	
114784	32	
115108	1310	
115589	1900	
115621	1100	

8
10/10/13SP

MS21042L6 Purchased No 100 Each 244.0000 4

 Nut


Location	Loc Qty	Loc Code
ST300	244	
111578	4	
114495	40	
115300	200	

4
10/10/13SP

MS27039-1-04 Purchased No 100 Each 353.0000 2

 SCREW

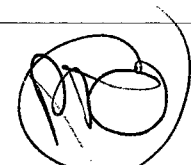
Location	Loc Qty	Loc Code
ST291	353	
115006	353	

2
10/10/13SP

MS27039-1-2 Purchased No 100 Each 0.0000 2

 SCREW

18057

2
2

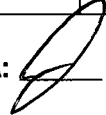


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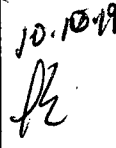
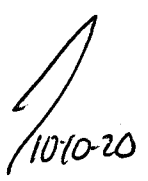
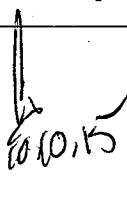
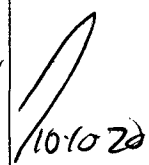
Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 10/02/20

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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10.10.15	100	MS27039-22 USED W/STAD OF MS27039-21. PC. NO STOCK.	 10/10/15	ACCEPTABLE DEVIATION, THIS W/O ONLY.	10.10.19 	 10/10/20	 10/10/15	 10/10/20

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Parent Item: PB67-43001-01



Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00



MS51859-6 Purchased No 100 Each 121.0000 4

 WASHER
 10/10/13 SL

Location	Loc Qty	Loc Code
ST296	121	
111279	21	
112940	100	



MS51859-7 Purchased No Each 25.0000 4

 Washer
 10/10/13

Location	Loc Qty	Loc Code
ST296	25	
111193	25	

MS51859-8 Purchased No 100 Each 63.0000 8

 WASHER
 10/10/13

Location	Loc Qty	Loc Code
ST296	63	
112940	63	

NAS1149DN632J Purchased No 100 Each 162.0000 6

 Washer
 10/10/13

Location	Loc Qty	Loc Code
ST297	162	
112794	62	
114382	100	

W/O:		WORK ORDER CHANGES					
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Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0316P Purchased No
WASHER

100 Each 287.0000 4 4

Location	Loc Qty	Loc Code
ST275	287	
112940	87	
113237	100	
113644	100	

NAS1149F0432P Purchased No
Washer

100 Each 290.0000 16 16

Location	Loc Qty	Loc Code
ST275	290	
112940	92	
114405	1	
114576	10	
114718	8	
115698	179	

NAS1149F0632P Purchased No
WASHER

100 Each 481.0000 8 8

Location	Loc Qty	Loc Code
ST275	481	
18057	481	

NAS1149F0832P Purchased No
WASHER

100 Each 275.0000 2 2

Location	Loc Qty	Loc Code
ST275	275	
18057	275	

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

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Work Order ID: 62583

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

NAS43DD3-68

Purchased

No

100

Each

34.0000

2

2



10/10/1358

SPACER

Location

Loc Qty

Loc Code

ST279

34

112410

34

2

PB67-43001-07

Manufactured

No

100

Each

0.0000

1

1



10.10.14 362308

Fwd Blade Fold Assembly Weldment

PB67-43001-11

Manufactured

No

100

Each

0.0000

1

1



10.10.14 362363

Fwf Adjustable Blade Support Assembly

PB67-43001-15

Manufactured

No

100

Each

0.0000

1

1



10.10.14 362366

Fwf Adjustable Blade Support Assembly

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

1



10.10.14 362370

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

1



10.10.14 362371

PB67-43001-23

Manufactured

No

100

Each

5.0000

2

2



10/10/1358

Lever Arm

Location

Loc Qty

Loc Code

ST432

5

52493

5

2

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Monday, October 04, 2010 1:48:22 PM

Page 11

Work Order ID: 62583

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-265

Manufactured No

100

Each

20.0000

4

4



Deltin Bushing



10/10/138 10.10.14

Location

Loc Qty

Loc Code

ST439

20

40056

15

52494

5

PB67-43001-299

Manufactured No

100

Each

20.0000

2



Bushing



4 10/10/138

Location

Loc Qty

Loc Code

ST439A

20

44969

20

PB67-43001-45

Manufactured No

100

Each

1.0000

1



Longitudinal Support



2 10/10/138

Location

Loc Qty

Loc Code

ST446

1

53249

1

PB67-43001-51

Manufactured No

100

Each

1.0000

1



Long T-Handle Assembly



1 10/10/138

Location

Loc Qty

Loc Code

ST446

1

53248

1

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

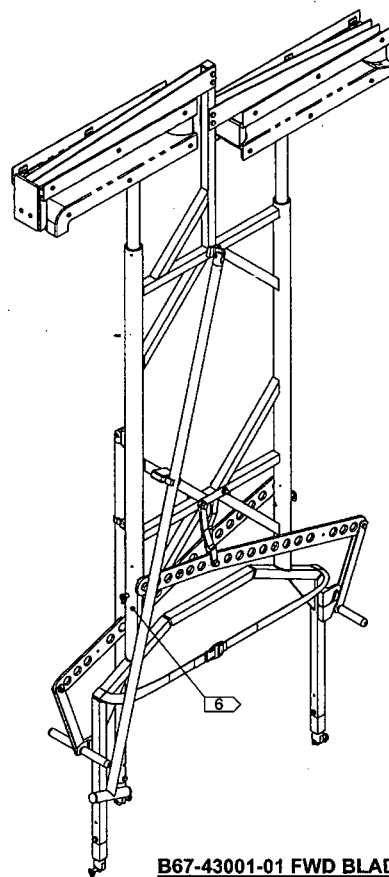
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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ITEM	QTY. -01	P/N	DESCRIPTION
	X	B67-43001-01	FWD BLADE FOLD ASSY
1	1	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-45	LONGITUDINAL SUPPORT
7	1	B67-43001-51	LONG T-HANDLE ASSY
8	2	B67-43001-261	LEVER ARM
9	4	B67-43001-265	DELTRIN BUSHING
10	2	B67-43001-299	BUSHING
11	1	D3445-041	BELT ASSEMBLY
12	2	D3447-3	SQUARE SPACER
13	2	D3447-7	CLEVIS
14	2	D3447-9	SWING ARM
15	1	D3451-041	HANDLE & LOCK-DOWN ASSY
16	1	D3451-047	HANDLE & LOCK-DOWN ASSY
17	2	D3922-1	CLIP
18	2	30345T22	LANYARD
19	2	30345T24	LANYARD
20	2	AN4-10A	BOLT
21	2	AN4-13A	BOLT
22	4	AN4-15A	BOLT
23	2	AN6-11A	BOLT
24	2	AN6-20A	BOLT
25	2	AN8-13A	BOLT
26	4	BSP43	RIVET
27	2	CR3213-4-05	RIVET
28	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
29	2	MS17984-C408	QUICK RELEASE PIN
30	2	MS17984-C418	QUICK RELEASE PIN
31	2	MS21042L3	NUT
32	8	MS21042L4	NUT
33	4	MS21042L6	NUT
34	2	MS27039-1-04	SCREW
35	2	MS27039-1-21	SCREW
36	4	MS51859-6	NYLON WASHER
37	4	MS51859-7	NYLON WASHER
38	8	MS51859-8	NYLON WASHER
39	2	NAS43DD3-68	SPACER
40	6	NAS1149DN632J	WASHER
41	4	NAS1149F0316P	WASHER
42	16	NAS1149F0432P	WASHER
43	8	NAS1149F0632P	WASHER
44	2	NAS1149F0832P	WASHER
45	A/R	242XX	LOCTITE 242 THREADLOCKER, BLUE




NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 49.07 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL Ø0.250 DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THROUGH THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL PER BUSHING).
- 10) PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MS51859 EQUIVALENT
- 11) TRIM HEAD OF MS17984-C408 QUICK PIN FLUSH TO BODY AS SHOW. TOUCH UP WITH BLACK PAINT PRIOR TO FASTENING TO FRAME.



B67-43001-01 FWD BLADE FOLD ASSY

RELEASED
2010-09-21

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 2 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR/09-011		VS	10.06.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VS			
CHECKED			DRAWING NO.	REV.
MFG. APPR.			B67-43001-01	SHEET 1 OF 2
APPROVED			TITLE	SCALE
DE APPR.	NA		FWD BLADE FOLD ASSY	NTS
DATE	10.06.11		COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

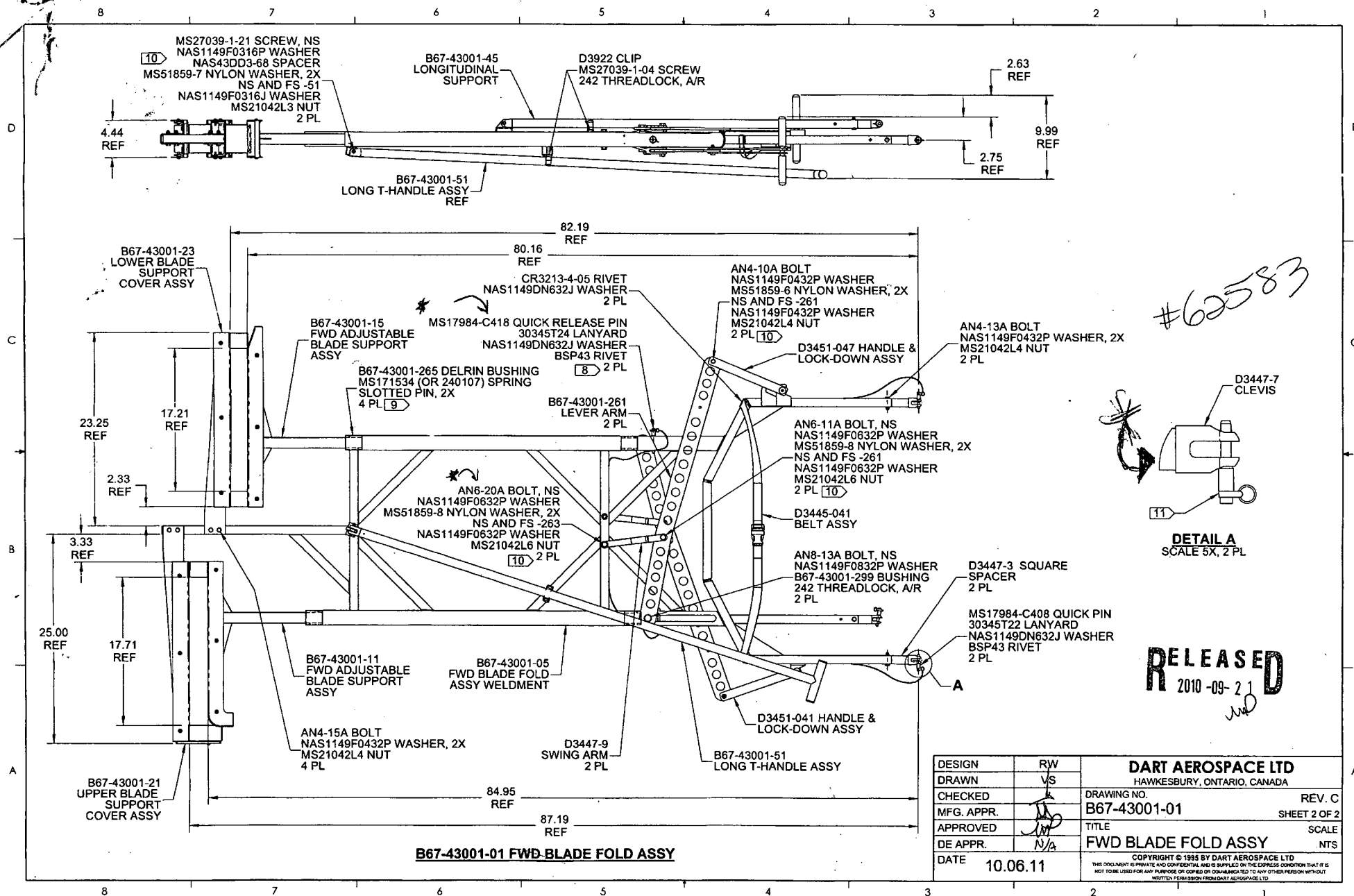
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DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-01	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FWD BLADE FOLD ASSY	NTS
DATE	10.06.11	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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